

Date: Tuesday, 27/05/2008 4:30:04 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 02.750 SUPPORT		
Job Number	: 39527			Part Number	: D28931		
Estimate Number	: 10829			Drawing Number	: D2893 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 27/05/2008	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 16/06/2008	Qty:	20
Previous Run	: 39061			Um:	Each		
Written By	:			 	 		
Checked & Approved By	: <u>JL 08.5.27</u>			 	 		
Comment	<p>: Est: C 02.11.26 Reformat; Added P/O KJ est D 06.04.19 removed alodine EC Est Rev:E Added priming as per Rev B 07-04-30 JLM est F 08.03.19 Re-format EC verified by: DD Est Rev:G 08-05-15 add QC14 DD verified by:EC</p>						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DSK078	D2893-1 TURNING DETAIL
		 <p>Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s) D2893-1 TURNING DETAIL Batch: <u>40802</u></p> <p style="text-align: right;"><u>JL 08/09/30</u></p>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 <p>Comment: HAAS 1 Machine as per Folio FA081 Tumble & Deburr</p> <p style="text-align: right;"><u>DTP08/10/02 JL 08/09/30</u></p>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <p>Comment: INSPECT ALL DIM TO DIM SHEET</p> <p style="text-align: right;"><u>DTP08/10/02 JL 08/09/30</u></p>
4.0	QC8	SECOND CHECK
		 <p>Comment: SECOND CHECK</p> <p style="text-align: right;"><u>8/08/10/05</u></p>
5.0	POWDER COATING	POWDER COATING
		 <p>M109152</p> <p style="text-align: right;">(20X)</p> <p>Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3. Mask Inside Bore for Priming</p> <p>START TIME: <u>9:10</u></p> <p style="text-align: right;"><u>M/L 08/10/07</u></p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/05/2008 4:30:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 39527

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

OP

Description :

OVEN TEMPERATURE:

400
9:40

FINISH TIME:

M-10 08/10/07

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS

08-10-07

X20

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

RT 08-10-21 X20

8.0 QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

AS 08-10-22 20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Y tube assy

RT 08-10-22 X20

10.0 QC21

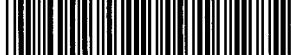
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/22 AS

Job Completion



W08/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39527
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.992	2.992	2.992	2.992	2.993
AB	0.440	0.460		0.440	0.440	0.440	0.440	0.440
AC	0.125	0.160		0.138	0.133	0.140	0.140	0.140
AD	0.040	0.060		0.050	0.050	0.042	0.042	0.042
AE	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AF	0.125	0.160		0.142	0.142	0.140	0.140	0.142
AG	0.140	0.160		0.154	-155	158	150	150
AH	1.360	1.400		1.375	1.363	1.369	1.370	1.366
AI	0.040	0.060		0.054	0.054	0.054	0.054	0.054
AJ	1.190	1.230		1.217	1.208	1.217	1.212	1.201
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.055	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.520	2.526	2.524	2.525	2.527
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.2635	0.2635	0.263	0.263	0.263
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: JTP 08/09/29/JL Date: 08/09/29/30

Audited by: SS Date: 08/10/01

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM <u>SS</u>	<u>SS</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39527
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				46	47	48	49	50
HAAS Section								
AA	2.985	3.005		2.993	2.993	2.993	2.992	2.992
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.135	.140	.140	.140	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.142	.142	.142	.142	.142
AG	0.140	0.160		.150	.151	.151	.153	.152
AH	1.360	1.400		1.367	1.370	1.373	1.367	1.371
AI	0.040	0.060		.049	.055	.047	.054	.047
AJ	1.190	1.230		1.210	1.218	1.213	1.216	1.212
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.527	2.528	2.527	2.526	2.526
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.263	.263	.263	.263
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: JL Date: 08/09/30

Audited by: SF Date: 08/10/08

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	SF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39527
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.993	2.993	2.993	2.993	2.994
AB	0.440	0.460		.440	.440	.440	.440	0.440
AC	0.125	0.160		.140	.140	.140	.140	0.140
AD	0.040	0.060		.050	.050	.050	.050	0.050
AE	0.188	0.193		.190	.190	.190	.190	0.189
AF	0.125	0.160		.142	.142	.142	.142	0.143
AG	0.140	0.160		.152	.154	.152	.153	0.150
AH	1.360	1.400		1.365	1.360	1.372	1.370	1.373
AI	0.040	0.060		.053	.047	.044	.055	0.047
AJ	1.190	1.230		1.205	1.207	1.212	1.216	1.214
AK	0.010	0.020		.015	.015	.015	.015	0.015
AL	0.053	0.073		.063	.063	.063	.063	0.055
AM	0.240	0.260		.250	.250	.250	.250	0.250
AN	2.518	2.538		2.528	2.527	2.528	2.528	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.263	.263	.263	0.263
AQ	0.053	0.073		.063	.063	.063	.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: JL /DJP Date: 08/10/01 / 08/10/02

Audited by: JL Date: 08/10/05

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	JL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29521
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1b	2f	3l8	419	520
HAAS Section								
AA	2.985	3.005		2.993	2.993	2.993	2.993	2.993
AB	0.440	0.460		0.440	0.440	0.440	0.440	0.440
AC	0.125	0.160		0.140	0.131	0.130	0.130	0.132
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AF	0.125	0.160		0.146	0.145	0.145	0.144	0.144
AG	0.140	0.160		0.150	0.150	0.148	0.151	0.151
AH	1.360	1.400		1.373	1.372	1.372	1.372	1.372
AI	0.040	0.060		0.050	0.048	0.050	0.050	0.050
AJ	1.190	1.230		1.214	1.218	1.218	1.219	1.220
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.055	0.055	0.055	0.055	0.055
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.263	0.263	0.263	0.263	0.263
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: DSP Date: 08/10/02

Audited by: SJ Date: 08/10/02

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

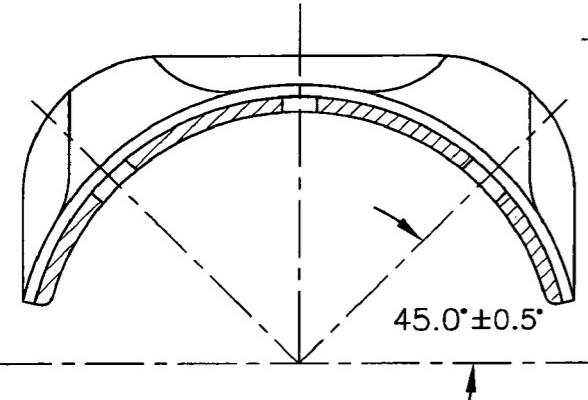
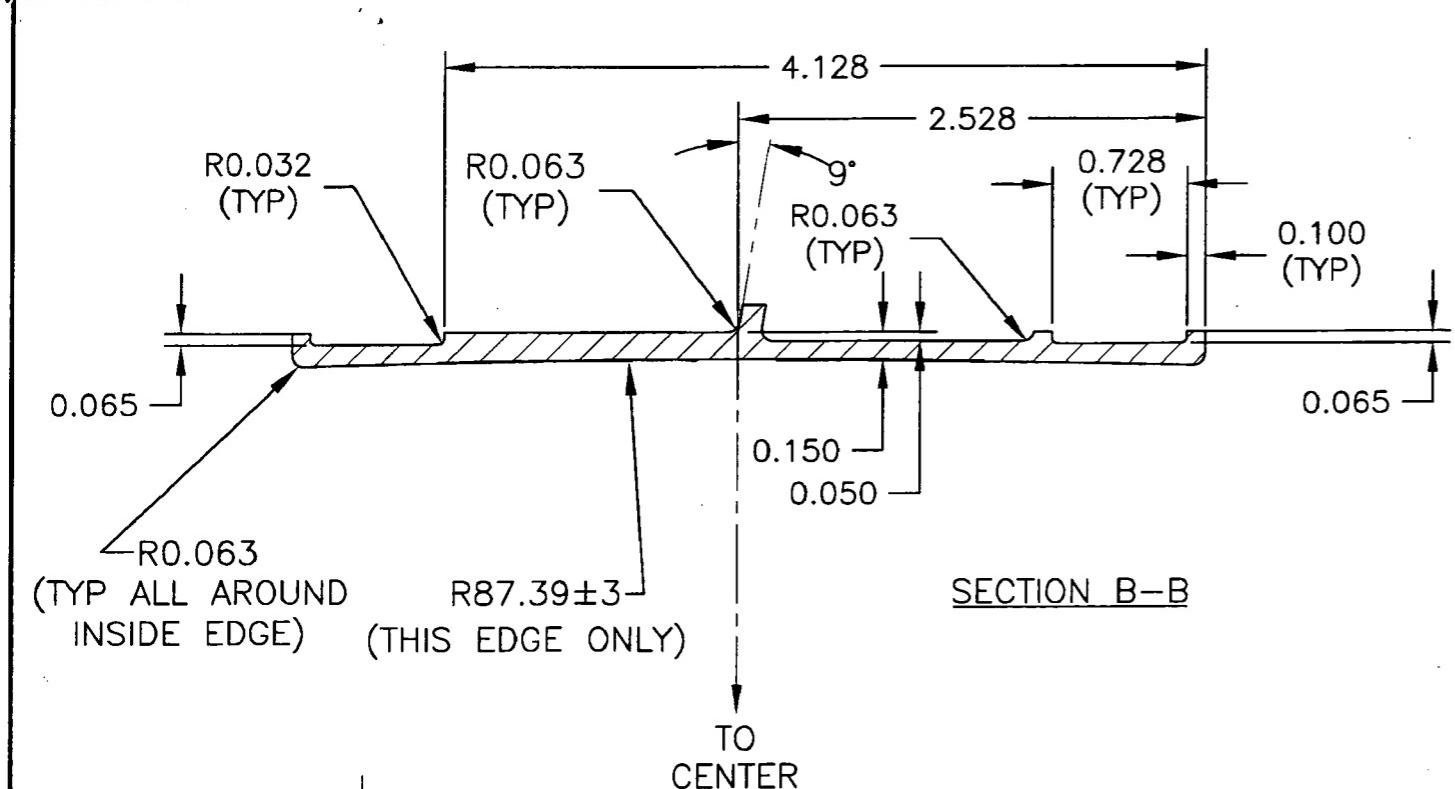
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

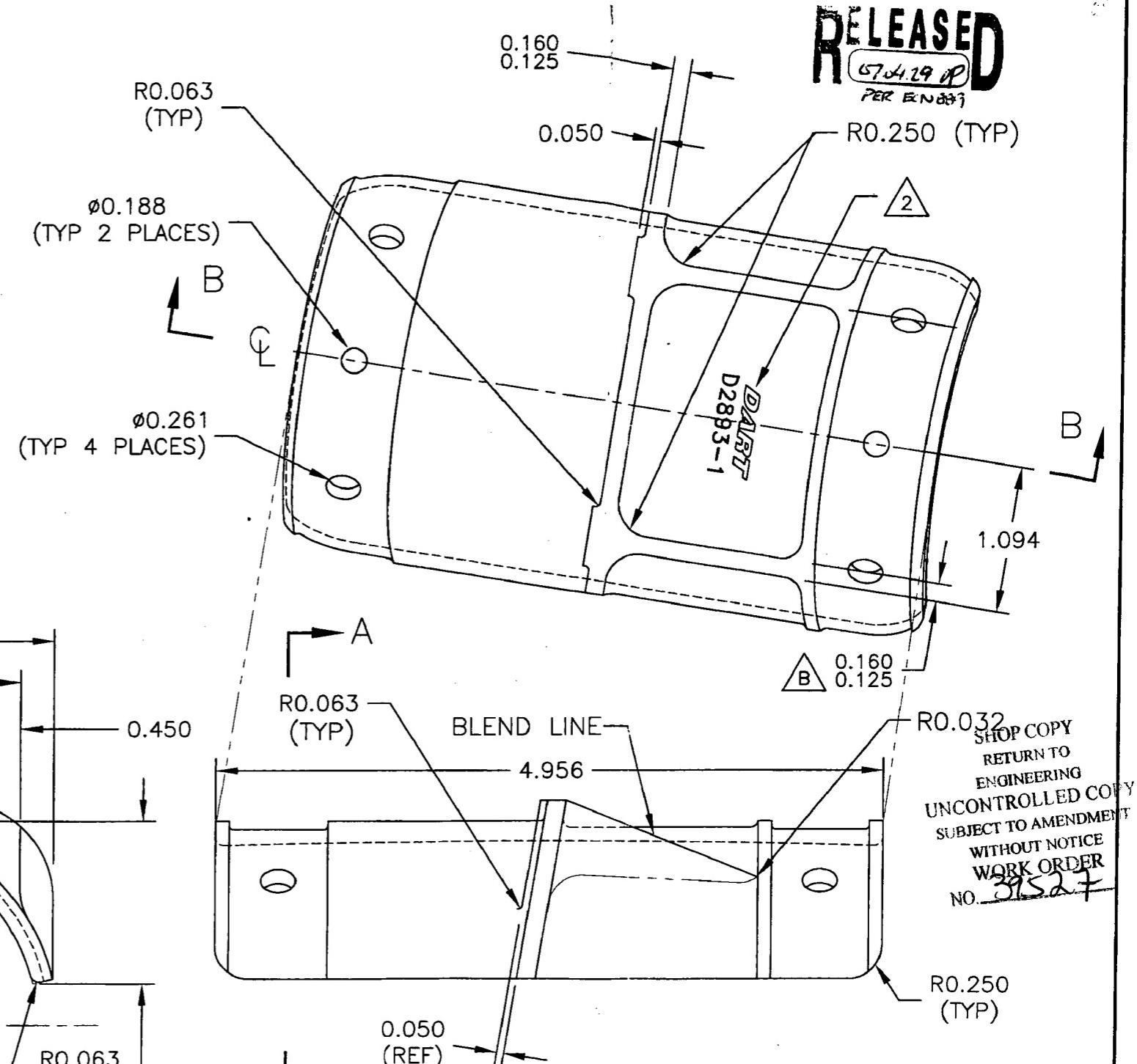
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
GJ4.19 OP
PER EN 893



- D2893-1
- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
 - 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
 - 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES
 - 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2



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DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2893
DATE		REV. B SHEET 1 OF 1 SCALE 1:1
07.03.16		TITLE Ø2.750 SUPPORT

